

# Work Order ID 71930

Wednesday, July 13, 2011 12:53:20 PM



Page 1

Item ID: D4281-1

Accept



Setup Start



Revision ID:

Item Name: Spacer

Stop



Start Date: 7/13/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *cmf*

Date: 11-07-13 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4281

A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

6061 .750x3,

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*11 07 18 (20)*

*11 07 18 (20)*

*Sulas/29*

*counts (20)*

*9*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan:

Date:

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Run Start




QC:

Date:

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Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Mill Conv	Manufacture as per dwg	0.00							
	<b>Memo</b>	0.00							
Conventional Milling Machine	1- Face to size as per dwg 2- deburr								
140  QC	QC6- Inspect dimensions to drawing	0.00							
	<b>Memo</b>	0.00							
Quality Control									
150  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
	<b>Memo</b>	0.00							
Hand Finishing									

11-7-26

20

Substg

counts  
420

420

4 M 11/07/29

W/O:		WORK ORDER CHANGES					
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Required Date: 7/22/2011 Req'd Qty: 20.00



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Reference:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<div> <div>Memo</div> <div>POWDER COAT:</div> <div>Start Time: 8:15</div> <div>Oven Temperature: 320 °F</div> <div>Finish Time: 8:45</div> </div>		0.00							
170  QC Quality Control	QC3- Inspect Part Finish	0.00							
Memo		0.00							
180  Packaging Packaging	Identify as per dwg & Stock Location: 139C	0.00							
Memo		0.00							

20x ✓ m/f 11/08/02

20 ✓ M 11/08/02

11/8/12 ✓ 20x

M117745

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/03

H/11-08-2  
20

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, July 13, 2011 12:53:18 PM

Work Order ID: 71930

Parent Item: D4281-1

Parent Item Name: Spacer



Page 1

Start Date: 7/13/2011

Required Date: 7/22/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC  
10.12.02 AS PER DWG REV.A DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X03.00 0		Purchased	No			100	f	49.5800	0.26333	5.543789			



11 07 19

Location

MAT003

104741

14252

15211

Loc Qty

49.58

21

8.58

20

Loc Code

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

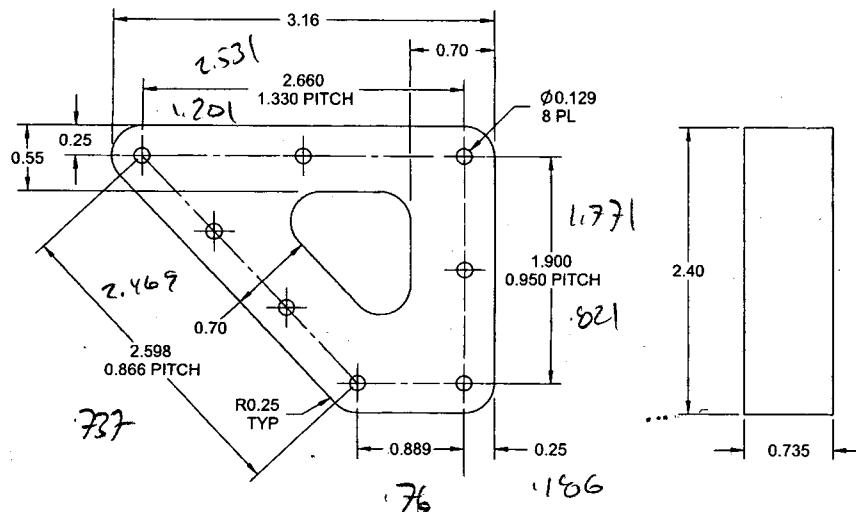
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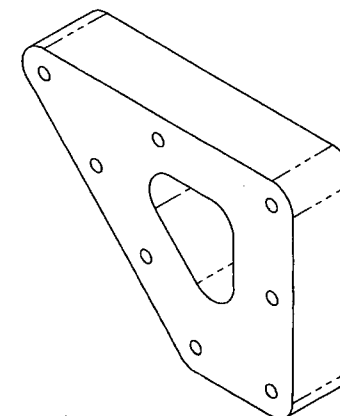
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**D4281-1 SPACER**



**D4281-1 SPACER**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

A NEW ISSUE		SC	10.11.25
REV.	DESCRIPTION		BY DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D4281	REV. A
MFG. APPR.			SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	10.11.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

064

W/O:		WORK ORDER CHANGES					
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